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D3859-041
Job Sheet 194348



18 12

Part No: D3859-041

Job Qty: 12 pcs

Part Name: Wearplate Assembly



Part Weight: 0 lbs

Status: New

Priority: Medium

Job Created: 5/1/19

Job Tracking No:

Due Date: 5/3/19

Created By: Shannon Hadley

Type: SOLD

Description:

Note: D3859 REV.C IPP Rev:A 09-02-03 new issue DD verified by:EC IPP Rev:B 14.04.30 as per dwg rev.b DD verified by:JLM IPP REV:C 17.11.17 AS PER DWG REV.C DD VERF:JFS

Ship Via:

Bill of Materials

Job Routing

Op No	Operation	Qty	Start Date	Due Date	Standard		Workcenter/Supplier		Sign-off
					Setup Hrs	Run Hrs	Workcenter / Supplier	Lead Time	
100	Waterjet - Flow - 1	12 pcs	5/3/19	5/3/19	0.00	1.84	Waterjet - Flow		2/19/05/11
110	QC 2	12 pcs	5/3/19	5/3/19	0.00	0.00	QC 2 - 1		
							QC 2 - 12		
							QC 2 - 14		
							QC 2 - 17		
							QC 2 - 19		
							QC 2 - 2		
							QC 2 - 20		
							QC 2 - 22		
							QC 2 - 23		
							QC 2 - 25		
							QC 2 - 32		
							QC 2 - 33		
							QC 2 - 35		
							QC 2 - 39		
							QC 2 - 4		
							QC 2 - 40		
							QC 2 - 44		
							QC 2 - 45		
							QC 2 - 48		2/19/05/11
							QC 2 - 49		
							QC 2 - 50		
							QC 2 - 51		
							QC 2 - 52		
							QC 2 - 57		
							QC 2 - 62		
							QC 2 - 63		
							QC 2 - 8		
							QC 2 - 66		
							QC 2 - 64		



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Container No: S180480



Part: D3859-041

Job No: 194348

Serial No/Batch: S180480

Revision: C

Inspector:

Exp Date:

Instructions: Various STC's

Date: 05/15/19

120 QC 8	12 pcs	5/3/19	0.00 0.00	QC 2 - 65	
				QC 2 - 5	
				QC 2 - 71	
				QC 8 - 12	
				QC 8 - 14	
				QC 8 - 17	
				QC 8 - 20	
				QC 8 - 25	
				QC 8 - 3	
				QC 8 - 32	
				QC 8 - 33	
				QC 8 - 35	
				QC 8 - 39	
				QC 8 - 4	
				QC 8 - 44	
				QC 8 - 45	
				QC 8 - 49	
				QC 8 - 58	
				QC 8 - 8	
				QC 8 - 9	
				QC 8 - 68	
				QC 8 - 67	
				QC 8 - 1 (A)	
				QC 8 - 47	
				QC 8 - 40	
				QC 8 - 52	
				QC 8 - 23	
					DAS MAY 13 2019 40 9-89
130 Large Fab - Welded Assy-2-B4B	12 pcs	5/3/19	0.00 20.34	Large Fab - 1 - B4B	EL
				Large Fab - 10 - B4B	
				Large Fab - 2 - B4B	
				Large Fab - 3 - B4B	
				Large Fab - 4 - B4B	
				Large Fab - 5 - B4B	
				Large Fab - 6 - B4B	
				Large Fab - 7 - B4B	
				Large Fab - 8 - B4B	
135 Automated Welding - B4B	12 pcs	5/3/19	0.00 1.20	Automated Welding - 1 - B4B	EL
140 QC 9	12 pcs	5/3/19	0.00 0.00	QC 9 - 10	
				QC 9 - 18	
				QC 9 - 24	
				QC 9 - 43	
				QC 9 - 50	
				QC 9 - 9	
150 QC 5	12 pcs	5/3/19	0.00 0.00	QC 5 - 10	
				QC 5 - 12	
				QC 5 - 17	
				QC 5 - 18	
				QC 5 - 19	
				QC 5 - 22	
				QC 5 - 24	
				QC 5 - 3	
				QC 5 - 43	
				QC 5 - 49	
				QC 5 - 51	
				QC 5 - 58	
				QC 5 - 68	
				QC 5 - 9	
					DAS MAY 21 2019 24 9-89

				QC 5 - 50			
				QC 5 - 30			
				QC 5 - 40			
180	Packaging 3-1 - Stock - B4B	12 pcs	5/3/19	0.00	0.00	Packaging 3 - 1 - B4B	
						Packaging 3 - 2 - B4B	
						Packaging 3 - 3 - B4B	
						Packaging 3 - 4 - B4B	STGLO
						Packaging 3 - 5 - B4B	MAY 21 2019
						Packaging 3 - 6 - B4B	
						Packaging 3 - 7 - B4B	
						Packaging 3 - 8 - B4B	
						Packaging 3 - 9 - B4B	
						Packaging 3 - 10 - B4B	
						Packaging 3 - 11 - B4B	
						Packaging 3 - 12 - B4B	
						Packaging 3 - 13 - B4B	
						Packaging 3 - 14 - B4B	
						Packaging 3 - 15 - B4B	
						Packaging 3 - 16 - B4B	
						Packaging 3 - 17 - B4B	
						Packaging 3 - 18 - B4B	
						Packaging 3 - 19 - B4B	
						Packaging 3 - 20 - B4B	
						Packaging 3 - 21 - B4B	
						Packaging 3 - 22 - B4B	
						Packaging 3 - 23 - B4B	
						Packaging 3 - 24 - B4B	
						Packaging 3 - 25 - B4B	
						Packaging 3 - 26 - B4B	
						Packaging 3 - 27 - B4B	
						Packaging 3 - 28 - B4B	
						Packaging 3 - 29 - B4B	
						Packaging 3 - 30 - B4B	
						Packaging 3 - 31 - B4B	
						Packaging 3 - 32 - B4B	
						Packaging 3 - 33 - B4B	
						Packaging 3 - 34 - B4B	
						Packaging 3 - 35 - B4B	
						Packaging 3 - 36 - B4B	DWG
190	QC 21 - SA	12 pcs	5/3/19	0.00	0.00	QC 21 - SA - 21	21
						QC 21 - SA - 70	9-09 MAY 21 2019
						QC 21 - SA - 53	

Part Op **100** - 1-Cut as per Dwg D3859-1 Dwg Rev: C Prog Rev: C 2-Deburr if necessary
 Descriptions: **110** - (QC2- Inspect parts off machine FAI/FAIB)
120 - (QC8- Inspect parts - second check)
130 - (Weld per dwg A/R S.S. rod Batch: _____) 1-Weld D4379-5 cups as per dwg D3859 A/R 316L stainless steel rod *****use DT9462 for welding***** 2- WELD HARDCOAT TO BAR 2059B HARDCOAT BATCH: _____ 3- POLISH WELS SURFACE AREA AS PER DWG NOTE2
135 - AUTO WELD HARDFACING 8259 BATCH: _____
140 - (QC9- Inspect visual per QSI004- Fusion Welds)
150 - (QC5- Inspect part completeness to step on W/O)
180 - (Identify as per dwg & Stock Location: _____)
190 - (QC21- Final Inspection - Work Order Release)

Job BOM

Part / Item	Component Name	Quantity	Operation	Container
M304S16GA	304/316 Sheet .063	10.2000 sf (.85 ea)	100-Waterjet - Flow - 1	
D4379-5	Wearplate Cup	72 pcs (6 ea)	130-Large Fab - Welded Assy-2- B4B	5159679

Job Allocations				
Operation	Component Part	Required	Inventory	Allocated
100-Waterjet - Flow - 1	M304S16GA	10	254	0
130-Large Fab - Welded Assy-2- B4B	D4379-5	72	102	0
Part Specifications				
Specifications could not be found.				

Plex 5/1/19 8:09 AM Dart.Hadley.Shannon